

Date: Wednesday, 15/10/2008 3:29:51 PM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : UPPER DOUBLER
Job Number : 42611	
Estimate Number : 12809	
P.O. Number :	Part Number : D36083
This Issue : 15/10/2008 S.O. No. :	Drawing Number : D3608 PRELIM
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : SMALL /MED FAB	Drawing Revision : PRELIM
Previous Run : 31511	Material :
Written By :	Due Date : 22/10/2008 Qty: 2 Um: Each
Checked & Approved By : <u>MF 08-10-15</u>	
Comment : Est Rev:A New Issue 07-03-26 JLM	
Est Rev:B 08-10-15 preliminary issue DD verified by:EC	

Additional Product

Job Number:



08.12.15
 SCRAP
 PRELIMINARY ISSUE

Seq. #:	Machine Or Operation:	Description :
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1.0	M304S22GA	304/316 .032,Sheet
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Comment: Qty.: 0.7762 sf(s)/Unit Total : 1.5523 sf(s)

304/316 .032 Sheet

Batch: 109087

HB 8-10-16

neg 1 cert's neg 1 (Charabi)

2.0	WATER JET 109087	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3608

Dwg Rev: PRE

Prog Rev: Lim

HB 8-10-16

②

2-Deburr if necessary

HB 8-10-16

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 8-10-16

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

HB 8-10-16

②

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1- deburr if necessary

2- Bend as per Dwg D3608

HB 8-10-16




① PD

ONE SCRAP - Don Scrap/CP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/10/17	H 5.0	one part scrap. Don Slow bent in wrong direction R.L. He got Distracted	 08/11/17	Scrap and Destroy No Replac Qty 40	 08/11/17	S 08/10/17	 08/11/17	S 08/10/17

NOTE: Date & initial all entries

Date: Wednesday, 15/10/2008 3:29:51 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UPPER DOUBLER

Job Number: 42611

Part Number: D36083

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 06/10/17 (X)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

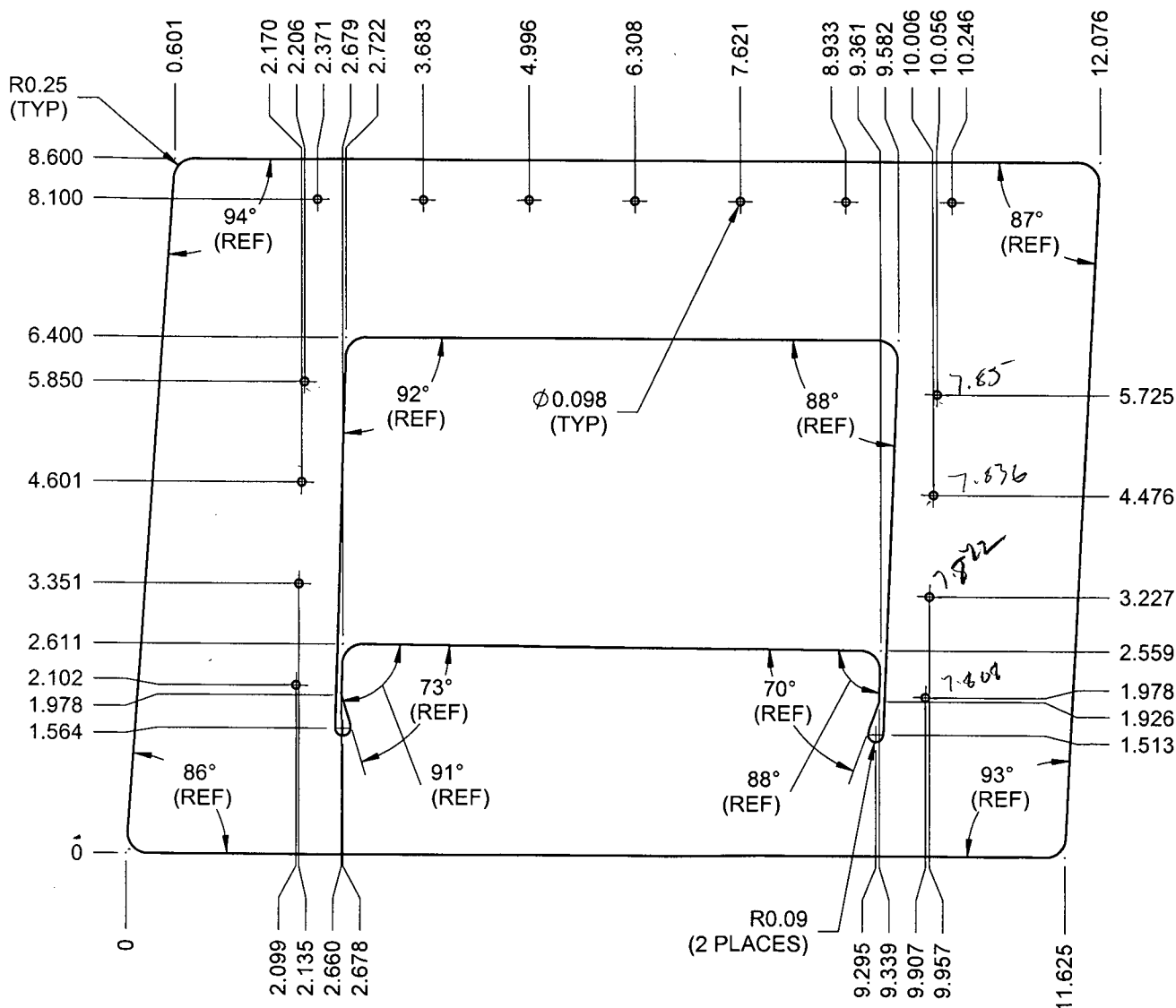


POSITIVE RECALL

EFFECT: 08/10/16 AUTH:

RELEASE: _____ DATE: _____

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED	DRAWING NO. D3608	REV. A SHEET 3 OF 3
DATE 07.04.11		TITLE DOUBLER	SCALE 1:2



D3608-3F UPPER DOUBLER

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 22 GAUGE
PER AMS 5513 OR AMS 5524 (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

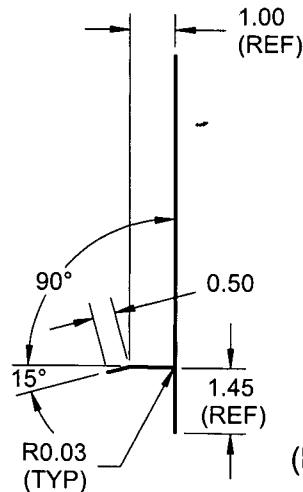
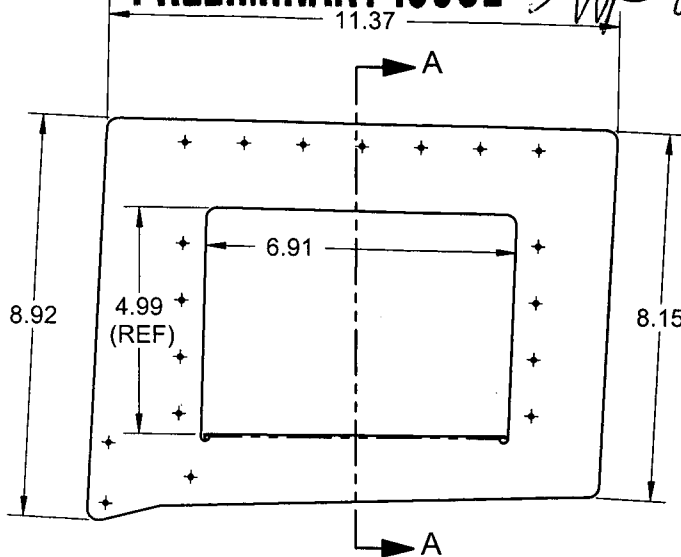
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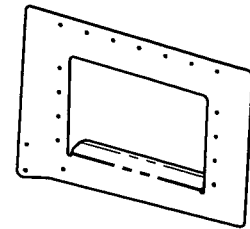
DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED	DRAWING NO. D3608	REV. A SHEET 1 OF 3
DATE 07.04.11	TITLE DOUBLER SCALE 1:4		
REV A	DATE 07.04.11	DESCRIPTION NEW ISSUE	

PRELIMINARY ISSUE

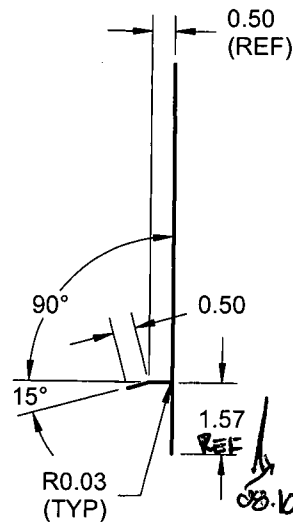
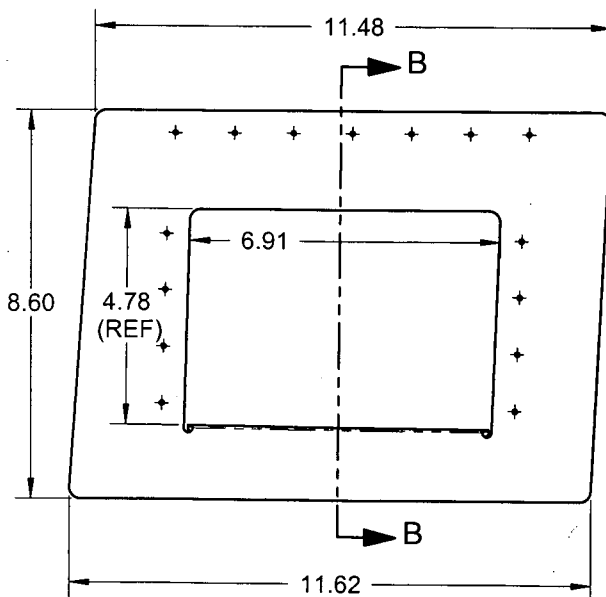
MP 08/19/15



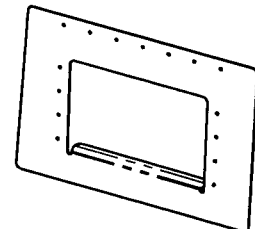
SECTION A-A



D3608-1 LOWER DOUBLER
(MAKE FROM D3608-1F)



SECTION B-B



D3608-3 UPPER DOUBLER
(MAKE FROM D3608-3F)

NOTES:

- 1) FINISH: NONE
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH DART P/N D3608-1 OR D3608-3 USING FINE POINT PERMANENT INK MARKER
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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*3.59
246*

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-775

Job #: 00264

Date: 08.10.15

Product Name: PROTECTIVE TRIMS

Requested By: DS

Design Manager Approval: _____

Quantity	Part Number	Category	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
2	D3608-1F	WJ	LOWER DOUBLER (FLAT PATTERN)	08.10.15	YES*		REQUIRED FOR FIT, FORM AND FUNCTION.*	
2	D3608-1F	GA	LOWER DOUBLER	08.10.15	PER -1F ABOVE		REQUIRED FOR FIT, FORM AND FUNCTION.*	
2	D3608-3F	WJ	UPPER DOUBLER (FLAT PATTERN)	08.10.15	YES*		REQUIRED FOR FIT, FORM AND FUNCTION.*	
2	D3608-3F	GA	UPPER DOUBLER	08.10.15	PER -3F ABOVE		REQUIRED FOR FIT, FORM AND FUNCTION.*	
							CONFORMITY IS MANDATORY.	

DART AEROSPACE LTD	Work Order: 42611
Description: Upper Doublet	Part Number: D3608-3
Inspection Dwg: D3608-3, Rev: PRELIM	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article

☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.101	*			
2.102	+ .010	2.101	*			
2.611	+ .010	2.612	*			
3.351	+ .010	3.356	*			
4.601	+ .010	4.606	*			
5.850	+ .010	5.852	*			
6.400	+ .010	6.408	*			
8.100	+ .010	8.106	*			
8.600	+ .010	8.606	*			
1.978	+ .010	1.979	*			
3.227	+ .010	3.229	*			
4.476	+ .010	4.480	*			
5.725	+ .010	5.730	*			
2.099	+ .010	2.094	*			
2.135	+ .010	2.130	*			
9.907	+ .010	9.907	*			
9.957	+ .010	9.957	*			
11.625	+ .010	11.625	*			
.601	+ .010	.609	*			
2.170	+ .010	2.165	*			
2.206	+ .010	2.201	*			
2.371	+ .010	2.368	*			
3.683	+ .010	3.680	*			

Measured by: RB
Date: 8-10-16

Audited by: [Signature]
Date: 08.10.17

Prototype Approval: [Signature]
Date: 08/10/17

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

